

Work Order ID 158491

Thursday, March 23, 2017 2:11:08 PM

158491

Page 1

Item ID: D119-796-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/7/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: 

Date:

MAR 22 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D119-796-021	A
--------------	---

IIN-D119-796	E
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100

Pick Kit

0.00

100

Packaging

Memo

0.02

Packaging

Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork

DAS
6
8-39

MAR 24 2017

110

0.00

110

HandFinish

Memo

1.37

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH: 136953

2-INSTALL DECAL D2729-4

IX 17/04/2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 158491

Thursday, March 23, 2017 2:11:08 PM

158491

Page 2

Item ID: D119-796-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection
Start Date: 4/3/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1			98
120									17-04-17
QC	Memo	0.50							
Quality Control									
130	Identify as per dwg & Stock Location: <i>Ship</i>	0.00				1x			17/04/17 98
130									
Packaging	Memo	0.25							
Packaging	Identify and pack for shipping as per PPP D119-796-021								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
21
9-88

APR 18 2017

DAS
21
9-88

APR 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 1

Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-646-041

Manufactured

No

100

Each

0.0000

2

2

D119-646-041

AW119 Replacement Skidtube with Wearpads - Fits LH or RH

D119-796-151

Manufactured

No

100

Each

3.0000

1

1

D119-796-151

FWD Crosstube Installation with Step (no hardware)

Location

Loc Qty

Loc Code

FG

3

151982

1

152472

1

156707

1

D119-796-251

Manufactured

No

100

Each

3.0000

1

1

D119-796-251

AFT Crosstube Installation with Step (no hardware)

Location

Loc Qty

Loc Code

FG

3

151970

1

152461

1

156705

1

B158278 (1x) B158278 (1x) **

17/04/10 SS
17/04/11 SS

17/04/11 SS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		☐ OTHER : _____					

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No 100 Each 605.0000 48 48

D2652

Bushing

**

MAR 21 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST009	361	
153807	361	
ST012a	200	
154965	200	

48
153807

D3407-041 Manufactured No 100 Each 26.0000 2 2

D3407-041

Tow Ring

**

MAR 24 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
st530	26	
106005	1	
110069	1	
153698	1	
155492	15	
157339	8	

2

D3417-5 Manufactured No 100 Each 76.0000 4 4

D3417-5

Washer

**

MAR 24 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
ST034	36	
151493	36	
ST038A	40	
156835	40	

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

100

Each

102.0000

2

2

D3456-1

Washer

MAR 24 2017

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

45

106784

1

152842

16

154870

25

156723

3

ST038A

50

157166

50

D3672-3

Manufactured No

100

Each

1,022.000

48

48

D3672-3

Washer, Phenolic

MAR 24 2017

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

197

132639

197

ST049

225

153292

225

ST051A

500

149295

0

153930

500

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

100

Each

1,115.000

48

48

D3672-7

Washer, Phenolic

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

21

129987

6

133986

15

ST049

94

152458

94

ST051A

1000

153039

500

157442

500

48

D3883-1

Manufactured No

100

Each

17.0000

2

2

D3883-1

Saddle, Outboard LH

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

17

153045

5

153815

12

2

D3883-2

Manufactured No

100

Each

6.0000

2

2

D3883-2

Saddle, Outside RH

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

6

152479

6

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

D3884-1

Manufactured No

100

Each

13.0000

2

2

D3884-1

Saddle, Inside LH

**

MAR 21 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST403

10

153739

10

ST404

3

152921

3

D3884-2

Manufactured No

100

Each

12.0000

2

2

D3884-2

Saddle, Inside RH

**

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST403

12

153801

12

D3886-041

Manufactured No

100

Each

22.0000

4

4

D3886-041

Lug Assembly

**

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST228

1

151001

1

ST525

5

153048

5

ST532A

16

153529

16

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

100

Each

120.0000

8

8

AN3C46A

Bolt

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

122843

10

OVER002

50

m136181

50

ST346

60

m136055

60

AN3C50A

Purchased

No

100

Each

380.0000

16

16

AN3C50A

Bolt

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

OVER002

352

M136503

200

M137074

152

ST346

28

M136348

28

AN4C6A

Purchased

No

100

Each

429.0000

24

24

AN4C6A

Bolt

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

228

m136318

128

m137026

100

ST345

187

m125709

32

m136047

155

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

100

Each

966.0000

24

24

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	203	
m130673	11	
m136182	192	
GA	215	
m133990	27	
m136182	188	
ST302	399	
m136986	399	
ST304	69	
m131340	69	

MAR 24 2017

DAS
6
9-89

MS21043-4

Purchased

No

100

Each

778.0000

26

26

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	17	
m132803	17	
ST302	721	
m136192	3	
m136263	118	
m136406	300	
m136983	300	

MAR 24 2017

DAS
6
9-89

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Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

100

Each

117.0000

8

8

MS21043-5

MAR 24 2017

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

71

116548

71

ST302

26

m135948

26

MS21250-05048

Purchased

No

100

Each

100.0000

8

8

MS21250-05048

133293 x 4 MAR 24 2017

Bolt (use MS21250-05-048)

Location

Loc Qty

Loc Code

over006

70

m135948

70

ST295

30

m135841

30

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

2,855.000

24

24

NAS1149C0332R

WASHER

MAR 24 2017

DAS
6
9-80

Location

Loc Qty

Loc Code

FP001

564

m136042

500

m136741

46

m136975

18

GA

532

m133284

32

m136444

500

ST260a

1700

m135408

0

m135766

500

m135908

200

m136643

1000

ST266

59

m127831

24

m135466

35

2y

NAS1149C0432R

Purchased

No

100

Each

1,518.000

48

48

NAS1149C0432R

WASHER

MAR 24 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136986

1000

ST266

145

m136182

145

126221

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 158491

158491

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

100

Each

408.0000

16

16

NAS1149C0532R

WASHER

MAR 24 2017

Location

Loc Qty

Loc Code

FP001

54

m135390

54

GA

42

116513

42

ST266

112

m135966

12

m136983

100

Sy266

200

m136192

200

139x89x35crate

Purchased

No

100

Each

0.0000

1

1

139x89x35crate

Agusta Crate

MS21920-28

Purchased

No

100

Each

65.0000

2

2

MS21920-28

Clamp

MAR 24 2017

Location

Loc Qty

Loc Code

FG

1

105884

1

LG050

40

M136579

15

M137075

25

LG051

1

M132169

1

LG057

2

M134130

2

st543

21

M136740

21

2

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DQA: _____ Date: _____



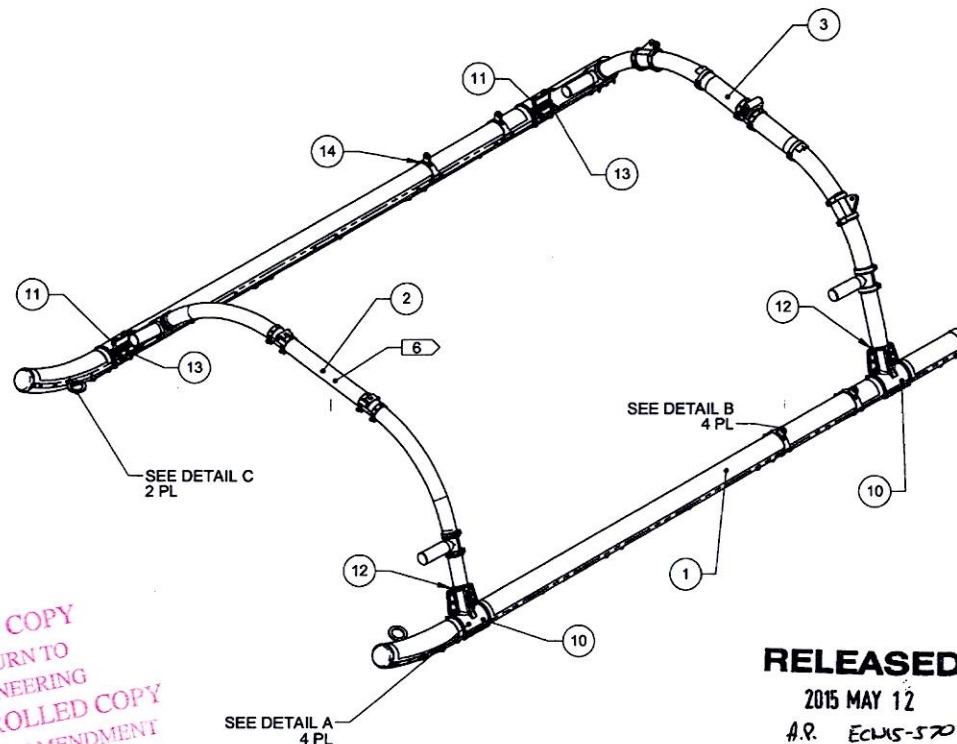
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158491
MAR 22 2017

D119-796-021 STD GEAR WITH STD WEARPADS

RELEASED

2015 MAY 12

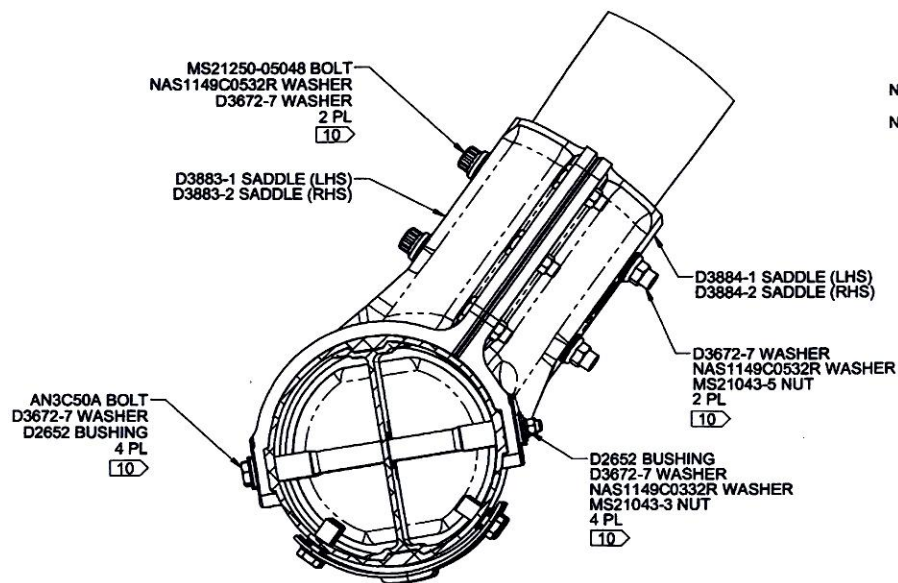
A.R. ECLMS-570

NOTES:

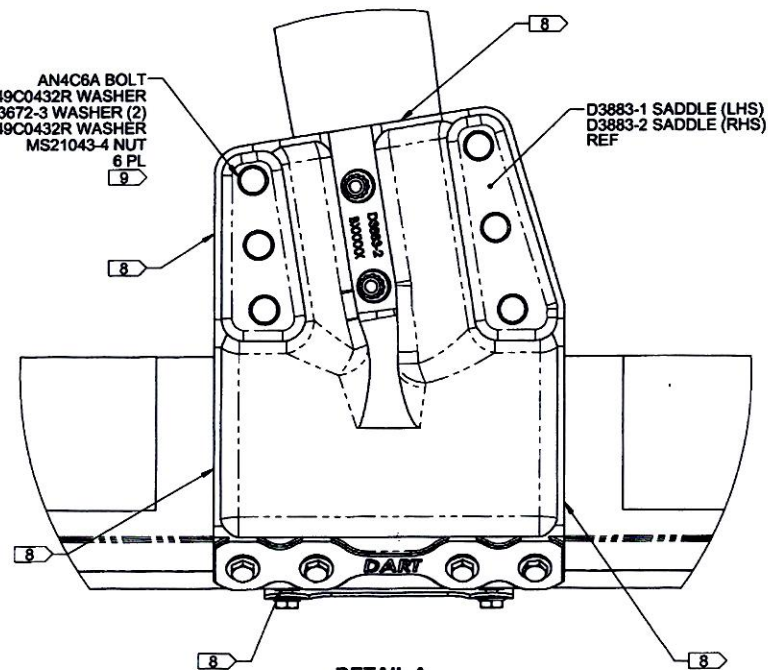
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

A		NEW ISSUE		AP	15.04.01
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-021 TITLE STD GEAR WITH STD WEARPADS		REV. A	
DRAWN	AP			SHEET 1 OF 4	
CHECKED	AJS			SCALE	
MFG. APPR.	DD			NTS	
APPROVED	HS				
DE APPR.	DS				
DATE		15.04.01			

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DETAIL A
4 PL



DETAIL A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

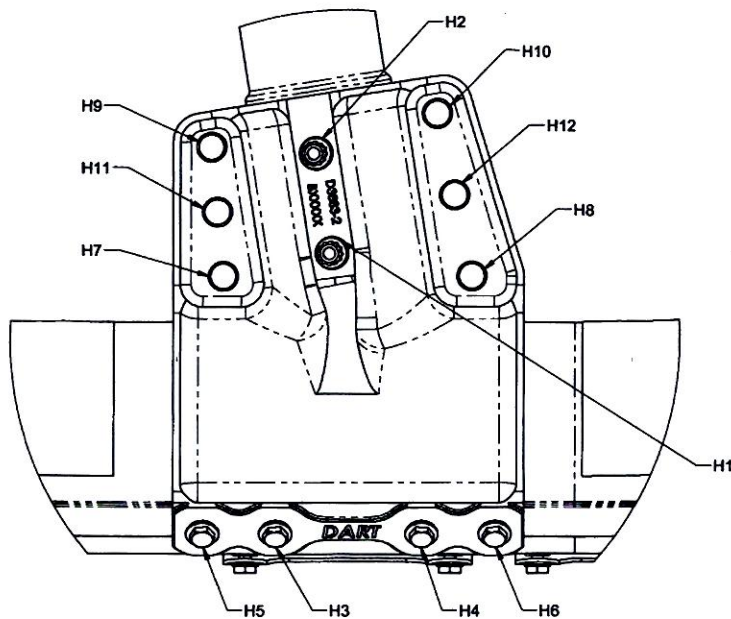
RELEASED

2015 MAY 12

A.P. EEN 15-570

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

2015 MAY 12
A.R. EWIS-STD

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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D3407-041 TOW RING
D3417-5 WASHER

9

INBOARD

D3417-5 WASHER
D3456-1 WASHER
MS21043-4 NUT

8 9 11

DETAIL C
2 PL

D2652 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

8 9 10

INBOARD

D3886-041 LUG ASSEMBLY

9

D2652 BUSHING
AN3C46A BOLT
2 PL

8 9 10

DETAIL B
4 PL

RELEASED

2015 MAY 12

A.P. Ecn15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
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